

Date: Tuesday, 16/12/2008 2:11:55 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X16")
Job Number	: 44118		
Estimate Number	: 12613		
P.O. Number	:	Part Number	: D120638011
This Issue	: 16/12/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2435 REV E1
First Issue	: //	Project Number	: N/A
Previous Run	: 41311	Drawing Revision	: E1
	Type	Material	:
	: MACHINED PARTS	Due Date	: 30/12/2008
Written By	:	Qty:	4
Checked & Approved By	: <u>1008-12-16</u>	Um:	Each
Comment	: Est Rev:A New Issue 07-01-02 JLM Est Rev:B Added Step 2 08-04-16 JLM Verified By:EC Est Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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H for CL 08/12/22

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

5 026/27

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING
 Program Batch Number

9-01-20

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 3.3604 sf(s)/Unit Total : 13.4417 sf(s)
 blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3
 Material: Black UHMW 1"
 (MUHMWB10) *109186x1*
 Batch: *110520* *18 9-1-20*

4.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 CUT BLANK AS PER FILE D2435

18 9-1-20

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Note: (2) Bearpaw for (1) Kit

J.L 09/01/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/12/2008 2:11:55 PM
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Seq. #:	Machine Or Operation:	Description :
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1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

3-Deburr

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

21 09/01/25

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 09/01/26

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 1.6660 f(s)/Unit Total : 6.6640 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2182B050

(5.00") Rubber Cushion

42737

B30870

88 09/01/27 (4)

10.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 D2274

Radius Block

B43838

2 D2435(ref only)

Bearpaw

88 09/01/27 (4)

11.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2438

Clamp

41428

88 09/01/27 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 44118

Part Number: D120638011

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 D2529 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer 42408

13.0 AN415A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A Bolt M109148

14.0 AN960JD416 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer M109249

15.0 MS21042L4 Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) M109282

16.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD120-638-011

Location: Rev A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D120638011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/28 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09.06.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44188
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.065 x 45°	✓			
B	5.500	+/-0.030	5.501	✓			
C	0.200	+/-0.030	.204	✓			
D	R0.250	+/-0.030	1.250	✓			
E	0.250	+/-0.010	.245	✓			
F	0.625	+/-0.030	.620	✓			
G	0.25 x 45°	+/-0.030	.265 x 45°	✓			
H	0.375	+/-0.010	.379	✓			
I	19.000	+/-0.030	19.00	✓			
J	0.950	+0.030/-0.010	.955	✓			
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.930	+/-0.030	.925	✓			
M	0.30	+0.030/-0.000	.310	✓			
N	0.375	+/-0.030	.380	✓			
O	7.375	+/-0.030	7.373	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	2.000	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.750	✓			

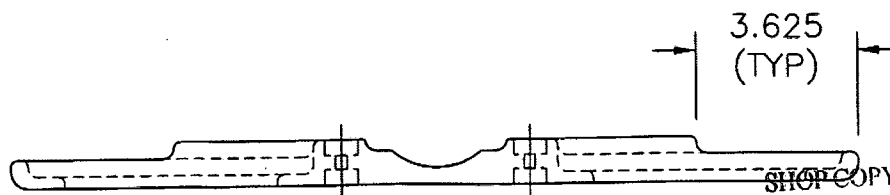
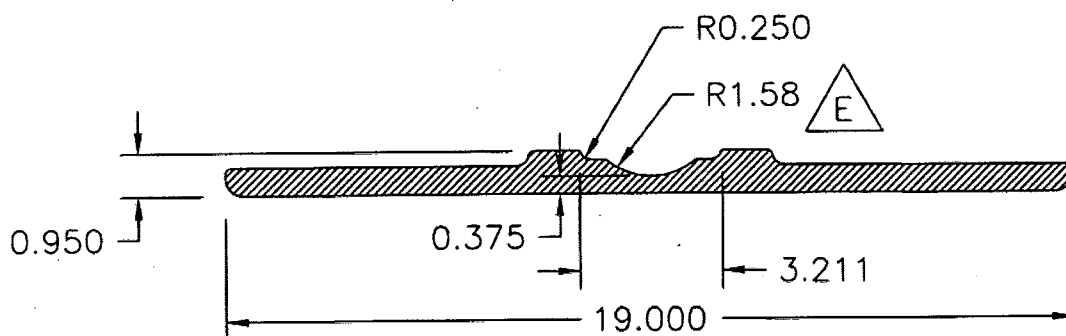
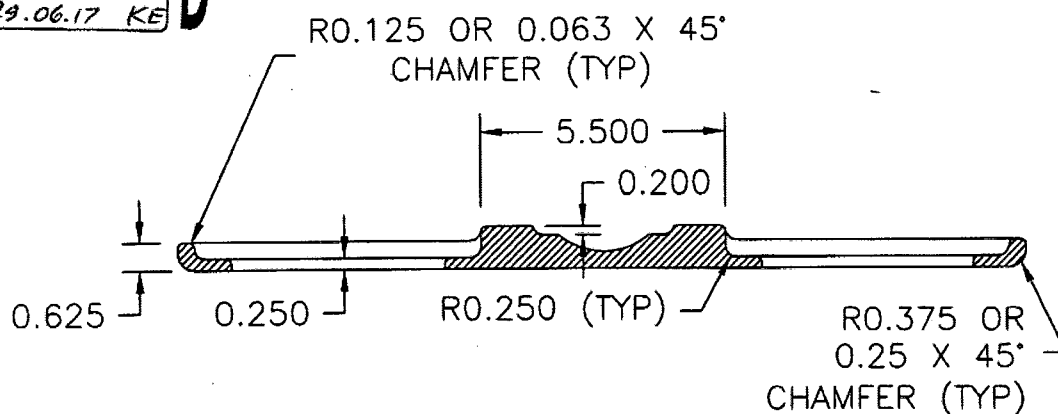
Measured by: J.L.	Audited by: S.S.	Prototype Approval: N/A
Date: 09/01/24	Date: 09/01/26	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>D18</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44118